

May 03, 2016 3:57:28 PM

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Tube

Stop *NS2*

Start Date: 5/9/2016 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 12.00

12

Customer:

Reference:

20160503

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):**Date:**

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 145178

May 03, 2016 3:57:28 PM

145178

Page 2

Item ID: 647.7714 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Tube
Start Date: 5/9/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/30/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130 Packaging Packaging	Memo ***Stock in large fab*** WA001	0.12				1/2 DAS 6 9:59			MAY 30 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	Memo	1.20				ML5			MAY 30 2016

ML5 MAY 30 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

May 03, 2016 3:57:36 PM

Page 1

Work Order ID: 145178

145178

Parent Item: 647.7714

647 7714

Parent Item Name: Strut Tube

Start Date: 5/9/2016

Required Date: 5/30/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.500W.083		Purchased			No		f	3.8970		7.578947		DAS	
M4130NT0 500W 083												32	
4130 RD tube .500 x .083W												9-89	16-05-27

Location

Loc Qty

Loc Code

MAT032

3.897

M134001

3.897

M134845

3.897

4.4691



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

C-CREATE
D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES
- 6 IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

20150503

SH
145178

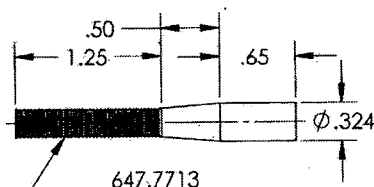
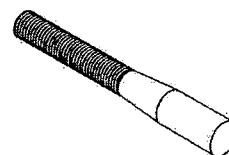
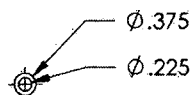
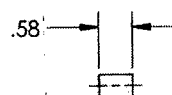
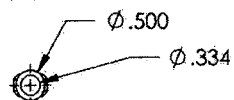
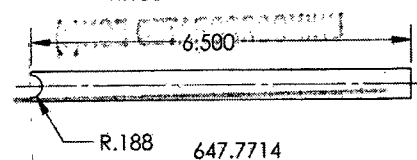
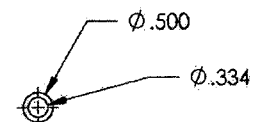
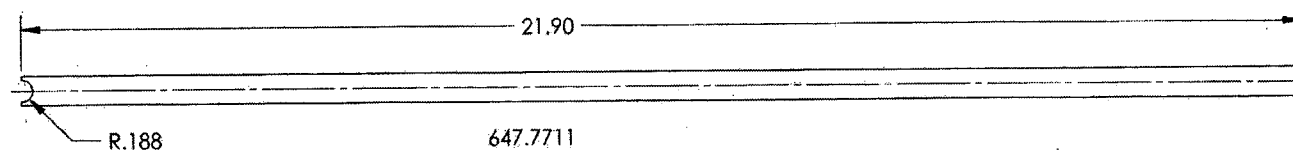
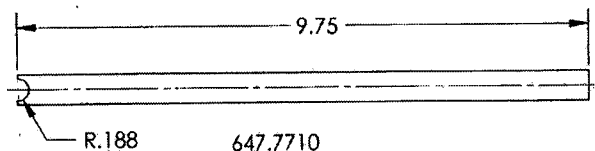
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY			DER REVIEW REQUIRED		
☐ MAJOR ☐ MINOR			☐ YES ☐ NO		

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE
	LAST PROTOTYPE REVISION PRO		N/C
M/C	INITIAL RELEASE	10/02/09	P. BRAVO
A	INCORPORATED ECH (4741)	11/15/14	P. BRAVO

			5	647.7714	STRUT TUBE		
1	1	1	4	647.7713	STRUT THREAD		
1	1	1	3	647.7712	STRUT TUBE		
	1		2	647.7711	STRUT TUBE		
		1	1	647.7710	STRUT TUBE		
				647.7703	STRUT ASSY		
				647.7702	STRUT ASSY		
				647.7701	STRUT ASSY		
7703	7702	7701	HND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PART LIST			
NEXT ASSY (\$)				APICAL INDUSTRIES			
647.7730				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300			
646.4000				STRUT ASSY			
QUANTITY DATE DRAWN BY J. MOORE CHECKED BY J. MOORE REVISIONS 1. REVISED APPROVE DATE CONTRACT NO.				SIZE (TAG CODE) DWG. NO. REV. A B 0747E 647.7700 COST CODE 647.7700 UNIT PRICE 647.7700			

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1/4 - 28 THREAD

FOREMAN DATE: 1/10/09 DRAWN BY: J. JACKSON DRAWING APPROVAL: P. BRAVO CONTRACT NO.:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE: 3 PLACES DECIMALS .001 2 PLACES DECIMALS .005 ANGLES 1/2°		SHEET: 8 CAGE CODE: 07A26 SCALE: NONE	DWG. NO.: 647.7700 REV. A SHEET 2 OF 2

